

## WHAT IS CLAIMED IS:

1. A method of making a hard-sided luggage article, said method comprising using a blow molding process to produce a base and a lid for said luggage article.
- 5           2. The method of Claim 1, including said lid having a double wall construction including an outer wall and an inner wall.
3. The method of Claim 2, including forming said inner wall with intermittent  
10 portions which contact an inner surface of said outer wall in order to impart torsional and compressive strength to said lid.
4. The method of Claim 3, including said base is formed with a Z-beam to  
15 receive said lid thereon;  
          said inner wall includes a groove section which mates with said Z-beam when said lid is received on said base; and  
          an extrusion attached to a section of said  
20 Z-beam.
5. The method of Claim 4, including said extrusion is a co-extrusion having a first portion which clips on to said section of said Z-beam and a second portion which extends laterally  
25 outwardly from said first portion.
6. The method of Claim 5, including said first portion is made from a first material and said second portion is made from a second material, said first material being harder than said  
30 second material.

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7. The method of Claim 6, including  
said base and lid have a first color and  
said second material has a second color, whereby said  
second portion creates a color break between said base and  
5 said lid.

8. A hard-sided luggage article comprising:  
a base;  
a lid secured to said base; and  
said base including an opening defined by  
10 a Z-beam.

9. The method of Claim 8, including an extrusion attached to a section of said Z-beam.

10. The method of Claim 9, including  
15 said extrusion is a co-extrusion having a  
first portion which clips on to said section of said  
Z-beam and a second portion which extends laterally  
outwardly from said first portion.

11. The method of Claim 10, including  
20 said first portion is made from a first  
material and said second portion is made from a second  
material, said first material being harder than said  
second material.

12. The method of Claim 11, including  
25           said base and lid have a first color and  
said second material has a second color, whereby said  
second portion creates a color break between said base and  
said lid.

13. The method of Claim 8, including  
30 said lid has a double wall construction  
including an outer wall and an inner wall.

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14. The method of Claim 13, including  
said inner wall has intermittent portions  
which contact an inner surface of said outer wall in order  
to impart torsional and compressive strength to said lid.

5 15. The method of Claim 14, including  
said inner wall includes a groove section  
which mates with said Z-beam when said lid is closed on  
to said base.

10 16. A hard-sided luggage article including a  
trap-door lid.

17. The method of Claim 16, including  
said luggage article including a base, said  
trap-door lid being hingedly connected to said base.

15 18. The method of Claim 17, including  
said lid and said base are separated by a  
parting line.

19. The method of Claim 18, including  
said base includes a bottom portion and a  
sidewall portion; and  
20 said parting line having a portion that is  
not disposed on said sidewall portion.

25 20. The method of Claim 19, including  
said portion of said parting line not  
disposed on said sidewall portion is where said lid is  
hingedly connected to said base.